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119-675-012 Dart Aerospace Ltd. Tuesday, 15/07/2008 9:15:05 AM Date: Julie Lecocq User: **Process Sheet** : A119 STEP WELDMENT RH Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 40483A : 10130 **Estimate Number** : D3043042 Part Number P.O. Number S.O. No. : Drawing Number : D3043 REV A : 15/07/2008 This Issue : N/A Project Number : NC Prsht Rev. : 11 : LARGE FAB ASSY **Drawing Revision** Type First Issue : 39068A Material **Previous Run** : 30/08/2008 Qty: 5 Um: **Due Date** Written By Checked & Approved By JLM' 05-11-01 : Est Rev : A New Issue Comment **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** D2622120C Step Extrusion 1.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Pick:D2622-120C extrusion B39316 Batch: LARGE FAB 1 LARGE FABRICATION RESOURCE 2.0 Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Deburr and bevel ends for welding INSPECT WORK TO CURRENT STEP QC5 3.0 Comment: INSPECT WORK TO CURRENT STEP 4.0 D2734 Step End Plate Comment: Qty.: 2.0000 Each(s)/Unit Total: -10.0000 Each(s) Pick: Qty Part Number Description Batch End Cap 2 D2734

D30401

2.0000 Each(s)/Unit Comment: Qty.: Total: 10.0000 Each(s) Pick:

> Qty Part Number Description Batch 2 D3040-1 Mounting Lug B38999

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Tuesday, 15/07/2008 9:15:05 AM Date: User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: A119 STEP WELDMENT RH Part Number: D3043042 Job Number: 40483A Job Number: Description: Seq. #: **Machine Or Operation:** D30403 Mounting Lug 6.0 2.0000 Each(s)/Unit 10.0000 Each(s) Comment: Qty.: Total: B.40492=5. 976=5 8P Qty Part Number Description Batch 2 D3040-3 Mounting Lug LARGE FAB 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 1-Weld 1 End Cap & Mounting Lugs, as per QSI 004 & Dwg D3043 Using DT8808 AL ROD Batch: 2-Grind Fwd End Cap weld flush QC9 8.0 Comment: VISUAL WELDING INSPECTION QC5 INSPECT WORK TO CURRENT STEP 9.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 10.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 1-Chemical Conversion Coat as per QSI 005 4.1 LARGE FABRICATION RESOURCE 1 11.0 LARGE FAB 1 Comment: LARGE FABRICATION RESOURCE 1 1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 AR AL ROD Batch: M /24855 -5208.10.10 2-Inspect for foreign object as per QSI 024

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Tuesday, 15/07/2008 9:15:05 AM Date: User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: A119 STEP WELDMENT RH Part Number: D3043042 Job Number: 40483A Job Number: **Description:** Seq. #: **Machine Or Operation:** 3-Grind Fwd End Cap weld flush VISUAL WELDING INSPECTION 12.0 QC9 Comment: VISUAL WELDING INSPECTION QC5 INSPECT WORK TO CURRENT STEP 13.0 WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 14.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 1-Touch up Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL QC3 15.0 POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT Inspect alodine POWDER COATING POWDER COATING 16.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE FINISH TIME: HAND FINISHING RESOURCE #1 17.0 HAND FINISHING m 109219 Comment: HAND FINISHING RESOURCE #1 1-Wing Walk as per Dwg D3043 and QSI 005 4.4 INSPECT POWDER COAT/CHEMICAL CONVERSION 18.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Date: User: Tuesday, 15/07/2008 9:15:05 AM

Julie Lecocq

Process Sheet

Custômer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 40483A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

PPP40483

08/10/15 (S)

20.0

Job Completion

QC21

FINAL INSPECTION/W/O RELEASE



PECTION/W/O RELEASE

Comment: FINAL IN



Dart Aerospace Ltd

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CHECK	CED M	APPROVED	DRAWING NO.	REV. A
	#	#	D3043	SHEET 1 OF 2
DATE			TITLE	SCALE
01.0	6.28		A119 STEP WELDMENT	NTS
Α		01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description	
Х		D3043-041	STEP WELDMENT, LH	
	Х	D3043-042	STEP WELDMENT, RH	
1	1	D2622-120	STEP EXTRUSION	
2	2	D3040-1	MOUNTING LUG	
2	2	D3040-3	MOUNTING LUG	
2	2	D2734	ENDPLATE	

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DRAWN BY DART AEROSPACE USA, INC. PORT HADLOCK, WA APPROVED DRAWING NO. CHECKED A REV. A D3043 SHEET 2 OF 2 TITLE DATE SCALE 01.06.28 A119 STEP WELDMENT 1:5 01.06.28 **NEW ISSUE** - 120.00 (DOES NOT INCLUDE ENDPLATES) — D3040-1 MOUNTING LUG 11.4 ENSURE HOLES (2 PLACES) (TYP) **ALIGN** -D3040-3 MOUNTING LUG (2 PLACES) 1.00 -D2734 ENDPLATE 45* (TYP BOTH ENDS) 0.875 +0.030 (TYP) 96.57 10.48 VIEW A-A: D3043-041 LH STEP WELDMENT - 120.00 (DOES NOT INCLUDE ENDPLATES) -D3040-1 MOUNTING LUG 11.4 ENSURE HOLES (2 PLACES) (TYP) **ALIGN** -D3040-3 MOUNTING LUG (2 PLACES) 1.00 D2734 ENDPLATE 45 (TYP BOTH ENDS) 0.875 +0.030 (TYP) 96.57 - 10.48 *-*SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED CO SUBJECT TO AMENDMEN WITHOUT NOTICE VIEW A-A: D3043-042 RH STEP WELDMENT

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